

Work Order ID 133653

Tuesday, June 16, 2015 6:59:23 AM

133653

Page 1

Item ID: D3272-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step

Start Date: 6/16/2015 Start Qty: 10.00

10

Required Date: 6/16/2015 Req'd Qty: 10.00

10

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: JUN 16 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3272	Rev B

100

0.00

100

Large Fab

Large Fab

Memo

0.05

Large Fab

SQUARE ONE END BEFORE CUTTING OTHER END

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Debur

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

11X DH 15/6/17

JUN 17 2015

DAS
24
9-89

11

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Item ID: D3272-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Step

Start Date: 6/16/2015 Start Qty: 10.00 *10* Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>WA3</u>	0.00				<u>11</u>	<u>JUN 17 2015</u>		<u>DAS 24</u> 9-89
120									
Packaging	Memo	0.00							
Packaging	LOCATION: WA003								
130	QC21- Final Inspection - Work Order Release	0.00							
130						<u>ML5</u>	<u>JUN 18 2015</u>		
QC	Memo	0.02							
Quality Control									

ML5 JUN 18 2015

Picklist Print

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Work Order ID: 133653

133653

Parent Item: D3272-1

D3272-1

Parent Item Name: Step

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120C

Manufactured

No

100

Each

108.9200

1

10

D2622-120C

Step Extrusion

OK 15/6/17

Location

Loc Qty

Loc Code

WA003

108.92

125381

3.92

130161

105

11



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *[Signature]*

△
B

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

15-06-16
NO. 133653 MLS
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

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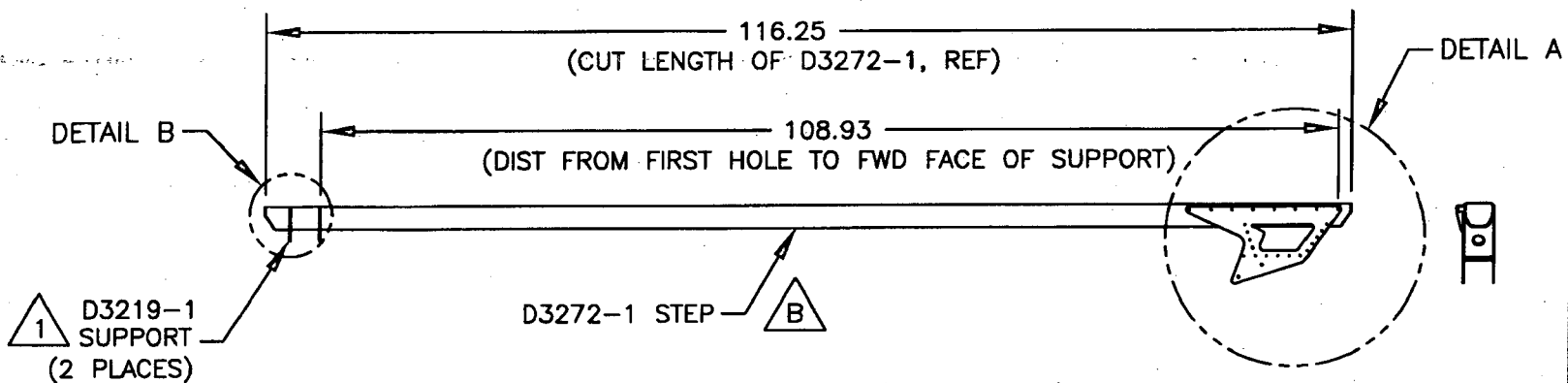
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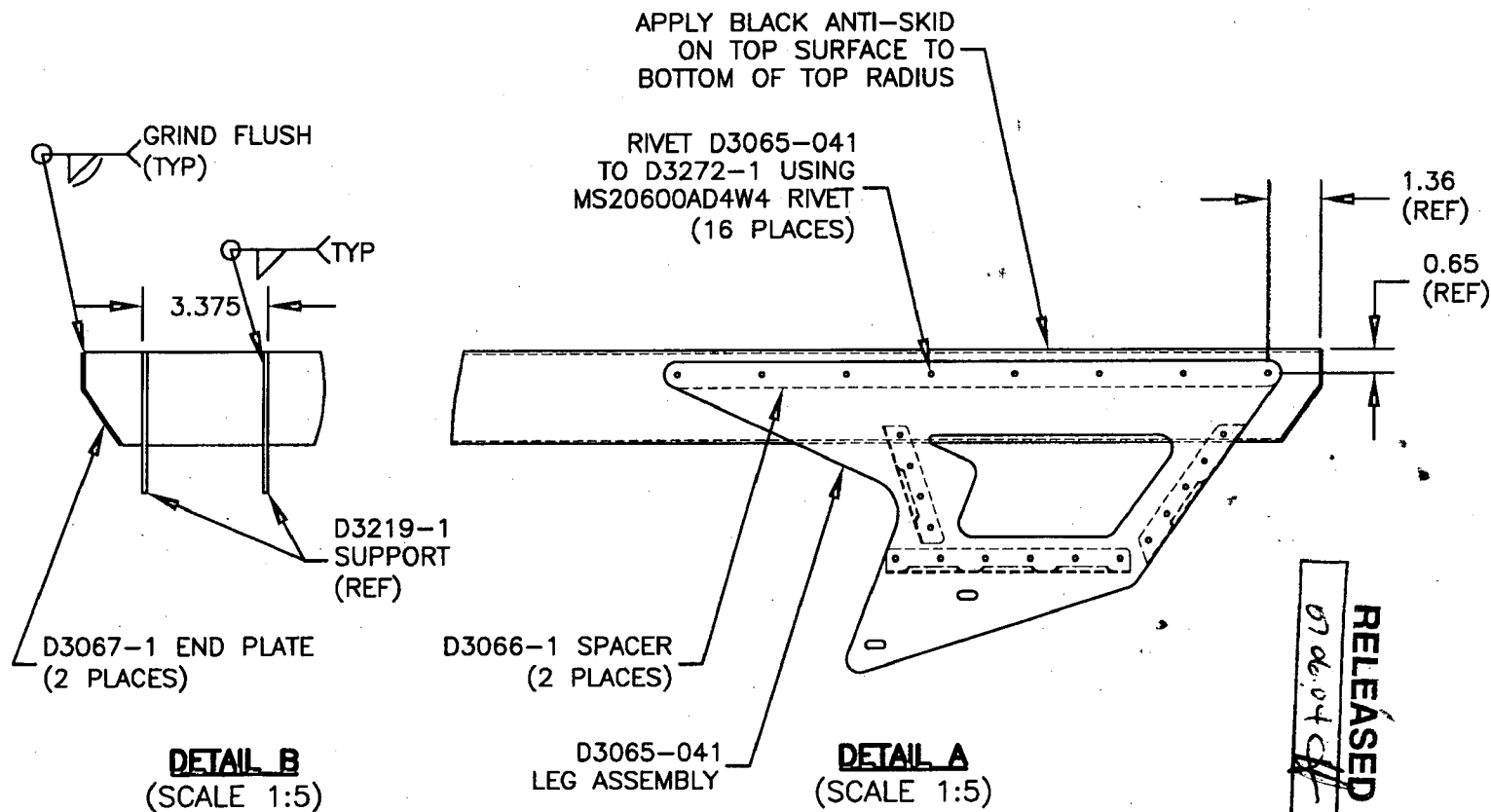
2

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DATE 07.05.18	DRAWING NO. D3272	REV. B
	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE 1:20

RELEASED
07.06.04



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

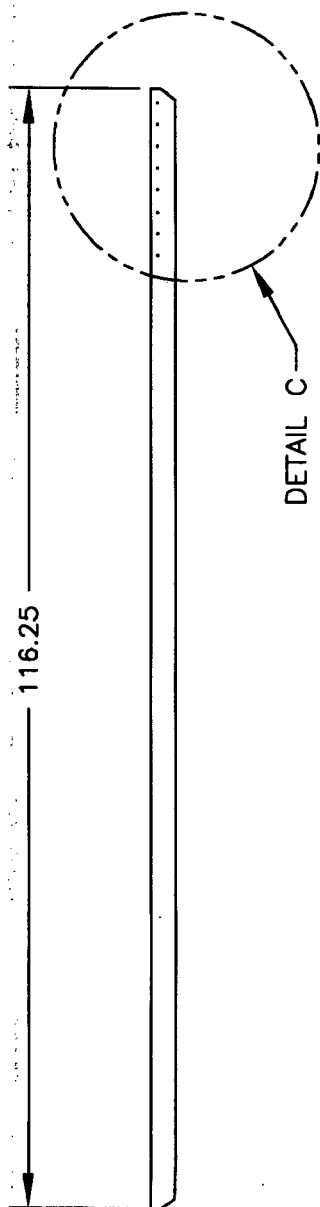




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DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

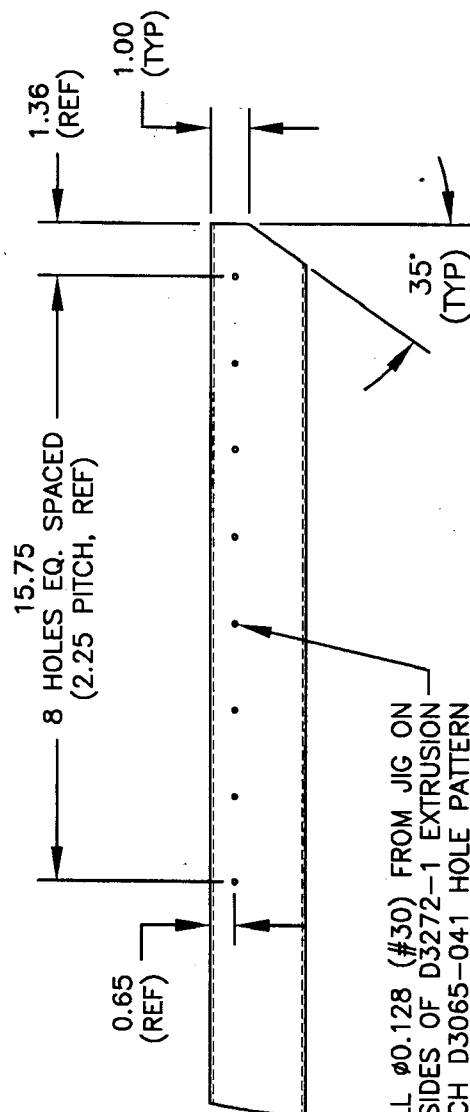
07.06.04 *[Signature]*



DETAIL C

△ B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

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